

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006869**Date Inspected:** 21-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/21/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 at Japan Steel Works, Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E3 - Assembled Saddle now awaits a Post Weld Heat Treat, while located in Fabrication Shop #4 QA Inspector noted one JSW personnel grinding locations of former temporary attach points.

W2W1 - As QA Inspector was performing his walk through, the assembled section was having temporary rigging supports removed by way of Carbon arc. The now assembled Saddle section is being repositioned to have the Cast stem to plate stem weld completed. Repositioning was still taking place, no welding occurred to W2W1 saddle section during QA Inspector's shift.

W2W2 - Saddle Cast section is moved to Machine Shop #2 per JSW representative Mr Hideaki Kon, for rough dimensional verification and some layout. Built up section was observed by QA Inspector as having contouring of welds followed by Magnetic Particle inspection completed by JSW Nikko Inspection personnel, Mr. M.Sato #81. Inspection process was still continuing as QA Inspector finished his tour of Fabrication Shop #4.

W2W3 - Welder T.Watanabe 08-5169, positioned on Plate 6-13 side of joint W3Y-11L, rib plate to base plate, is in process of depositing a root pass, utilizing 4mm E9018M electrode (SMAW). Mr. M.Sato MT technician stands by to perform MT of first of passes to make up the root. Makhmud Ashadi, performed weld parameter verification to assure requirements of WPS SJ-3011-2 were met.

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TOWER SADDLES

T1-2 - During the QA Inspector's observance of Tower Saddle T1-2, welder S.Watanabe 08-5159 was joining plate end rib to base plate, joints 8Y-12L-1 and -2, using E7016 electrode, 5mm, and WPS SJ-3012-2. These welding operations continued through to end of QA Inspectors shift, QC CWI Mr. Makhmud Ashadi reviewed parameters to verify same values still exist from day shift QC Mr. Chung Fu Kuan.

T1-3 - Saddle is in process of being repositioned to begin welding processes, no welding is likely to occur until "C" shift, due to need to meet its preheat temperature. As QA Inspector was leaving the Fabrication shop, the tower saddle had yet been secured in place.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
